RESISTANCE TO ACID/ALKALINE SOLUTIONS .... Excellent

In very aggressive acid solutions such as those found in the chemical milling of steel and titanium, AC-832 Topcoat may be desired.

PRODUCT PRECAUTIONS

DANGER! AC-816 CONTAINS perchloroethylene. VAPOR HARMFUL. HARMFUL OR FATAL IF SWALLOWED. KEEP OUT OF REACH OF CHILDREN. Keep away from heat, sparks, and open flame. Keep container closed when not in use. Use only with adequate ventilation. Avoid prolonged or repeated breathing of vapor. Avoid prolonged or repeated contact with skin. DO NOT TAKE INTERNALLY. FIRST AID: If swallowed, INDUCE VOMITING. CALL A PHYSICIAN IMMEDIATELY. Move patient to fresh air. Apply artificial respiration if not breathing. See MSDS for additional information.

PRODUCT PACKAGING

AC-816 is furnished in 5 gallon pails, 55 gallon F.O.T. steel drums, and, by special arrangement in 350 gallon liqui-bins.

PRODUCT USE INSTRUCTIONS

GENERAL - The directions and recommendations given below are intended to serve as a guide and may need modification to meet local conditions.

MIXING - AC-816 should be thoroughly mixed prior to use and remixed at least every 4 hours. Avoid introducing air into the coating during mixing. Parts must be clean and dry before coating for optimum performance.

THINNING - Use AC-816 as received. Should the material thicken during use due to evaporation, thin with perchloroethylene to retain compliance with A.P.C.D. requirements. Maintain the viscosity of the dip tank at 28 to 32 seconds viscosity in a #5 Zahn cup @ 75°F. For each 5°F. fluid temperature rise the viscosity will be reduced by 1 sec. Example: At a maskant temperature of 90°F. the optimum viscosity is 28 sec. in a #5 Zahn cup.

RECOMMENDED DRY FILM THICKNESS - Six to fourteen mils, depending on the process requirements.

CURE CYCLE - Allow the film to air cure for 4 hours minimum at 75°F. or above. At lower temperatures allow additional curing time. AC-816 films may be baked at 150°F. to 200°F. for 30 to 60 minutes after an initial air cure of 1 to 2 hours should faster processing be required. NOTE: AC-816 may be baked for 30 to 60 minutes @ 255°F. when used in plating and anodizing solutions for optimum results. The bake cycle should follow the normal air cure. Aluminum parts to be anodized after chemical milling need not be baked.

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